

Work Order ID 148457

148457

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June 30, 2016 2:11:49 PM

Item ID: D205-541-045 Accept *N900040100* Setup Start *NS1*
 Revision ID: Stop *NS2*
 Item Name: Heli-Utility-Basket™ - LH Low Profile
 Start Date: 7/8/2016 Start Qty: 1.00 *1* Cust Item ID:
 Required Date: 7/25/2016 Req'd Qty: 1.00 *1* Customer:
 Reference:

Approvals: Process Plan: 34 Date: 6/30/16 Tooling: _____ Date: _____ Run Start *NR1*
 QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop *NR2*

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
Draw Nbr	Revision Nbr								
DSI9667	A	PC JUL 22 2016							
IIN D205-541	J								

100 Document Control 0.00
 100 DOCUMENT CONTROL
 DC Memo 0.00
 Doc.Control -USB or Paperwork Photocopy bluefile & type labels per PPPD205-541-045 CHG002

DAS
27
9-89

JUL 29 2016

110 Small Fab 0.00
 110 Small Fab Memo 0.23
 Small Fab 1-install bumper as per dwg D3712 2-Assemble as per IIN 205-541-045

12/16/07/29

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____		DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐		AGAINST DEPARTMENT/PROCESS <table style="width: 100%; border: none;"> <tr> <td style="border: none;">Skid-tube ☐</td> <td style="border: none;">Cross tube ☐</td> <td style="border: none;">Water Jet ☐</td> <td style="border: none;">Engineering ☐</td> </tr> <tr> <td style="border: none;">Machining ☐</td> <td style="border: none;">Small Fab ☐</td> <td style="border: none;">Prod. Eng. Coord. ☐</td> <td style="border: none;">Quality ☐</td> </tr> <tr> <td style="border: none;">Thermoforming ☐</td> <td style="border: none;">Finishing ☐</td> <td style="border: none;">Rec/Store/Packaging ☐</td> <td style="border: none;">Other ☐</td> </tr> <tr> <td style="border: none;">Large Fab ☐</td> <td style="border: none;">Composite ☐</td> <td style="border: none;">Supplier ☐</td> <td style="border: none;"></td> </tr> </table>						Skid-tube ☐	Cross tube ☐	Water Jet ☐	Engineering ☐	Machining ☐	Small Fab ☐	Prod. Eng. Coord. ☐	Quality ☐	Thermoforming ☐	Finishing ☐	Rec/Store/Packaging ☐	Other ☐	Large Fab ☐	Composite ☐	Supplier ☐	
Skid-tube ☐	Cross tube ☐	Water Jet ☐	Engineering ☐																						
Machining ☐	Small Fab ☐	Prod. Eng. Coord. ☐	Quality ☐																						
Thermoforming ☐	Finishing ☐	Rec/Store/Packaging ☐	Other ☐																						
Large Fab ☐	Composite ☐	Supplier ☐																							
Date :		Step #:		QTY Effective :			MRB (QSI042) Approval																		
Description Work Order Deviation				Disposition				Completed By																	
								Lead hand / Supervisor Approval Verification																	
								QC / QA Coordinator Approval																	
Root Cause		FAULT CATEGORY																							
Environment ☐ Design ☐ Doc/Data ☐ Equip/Tooling ☐ Handling/Pre ☐ Material ☐ Internal Transport ☐ Tribal Knowledge ☐ LOA ☐ Substation ☐ Past Expiry Date ☐ Misidentified ☐	No Re-verification ☐ Operator ☐ Offset/Setup ☐ Supplier ☐ Training ☐ Use for Testing ☐ Poor Information ☐ Rushing ☐ Product Improvement ☐ Process Improvement ☐ Manufacturing Process ☐ Past Due ☐	Pressure/Forced ☐ Bending ☐ Centre Not Concentric ☐ Cracks ☐ Crimp/Kink/Ripple/Wave ☐ Cuffs ☐ Crushing ☐ Heat Treat ☐ Wave/Twist in Tube ☐ Marks/Chatter ☐				Temperature/Cure ☐ Set-up ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Inspection Incomplete/Unqualified ☐ Contamination ☐ Countersink ☐ Cut Too Short ☐ Instructions Incomplete/Unclear ☐ Drill Holes ☐				Power Loss/Surge ☐ Folio/Program ☐ Grain ☐ Weld ☐ Wrong Stock Pulled ☐ Out of Sequence ☐ Off-set ☐ Mislabeled ☐ Fit/Function ☐ Misaligned/off center ☐				Positioned Wrong ☐ Outside Dimensions ☐ Over/Under tolerance ☐ Part Incorrect ☐ Part Lost/Missing ☐ Part Moved ☐ Drawing ☐ Finish ☐ Misread ☐ Turning Sequence ☐											
OTHER : _____																									

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Item ID: D205-541-045 Accept ***N900040100*** Setup Start ***NS1***
 Revision ID: Stop ***NS2***
 Item Name: Heli-Utility-Basket™ - LH Low Profile
 Start Date: 7/8/2016 Start Qty: 1.00 ***1*** Cust Item ID:
 Required Date: 7/25/2016 Req'd Qty: 1.00 ***1*** Customer:

Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____ Run Start ***NR1***
 QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
120	QC5- Inspect part completeness to step on W/O	0.00							DAS 38 9-89
120									
QC	Memo	0.00							
Quality Control									JUL 29 2016
130	Pick Kit	0.00							
130									
Packaging	Memo	0.00							
Packaging									
140	QC4- 100% Inspect kits for completeness	0.00							
140									
QC	Memo	0.01							
Quality Control									

JUL 29 2016

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____ Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____		DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐		AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐					
Date :		Step #:		QTY Effective :			MRB (QSI042) Approval Completed By Lead hand / Supervisor Approval Verification QC / QA Coordinator Approval		
Description Work Order Deviation				Disposition					

Root Cause		FAULT CATEGORY					
Environment ☐ Design ☐ Doc/Data ☐ Equip/Tooling ☐ Handling/Pre ☐ Material ☐ Internal Transport ☐ Tribal Knowledge ☐ LOA ☐ Substation ☐ Past Expiry Date ☐ Misidentified ☐	No Re-verification ☐ Operator ☐ Offset/Setup ☐ Supplier ☐ Training ☐ Use for Testing ☐ Poor Information ☐ Rushing ☐ Product Improvement ☐ Process Improvement ☐ Manufacturing Process ☐ Past Due ☐	Pressure/Forced ☐ Bending ☐ Centre Not Concentric ☐ Cracks ☐ Crimp/Kink/Ripple/Wave ☐ Cuffs ☐ Crushing ☐ Heat Treat ☐ Wave/Twist in Tube ☐ Marks/Chatter ☐	Temperature/Cure ☐ Set-up ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Inspection Incomplete/Unqualified ☐ Contamination ☐ Countersink ☐ Cut Too Short ☐ Instructions Incomplete/Unclear ☐ Drill Holes ☐	Power Loss/Surge ☐ Folio/Program ☐ Grain ☐ Weld ☐ Wrong Stock Pulled ☐ Out of Sequence ☐ Off-set ☐ Misabeled ☐ Fit/Function ☐ Misaligned/off center ☐	Positioned Wrong ☐ Outside Dimensions ☐ Over/Under tolerance ☐ Part Incorrect ☐ Part Lost/Missing ☐ Part Moved ☐ Drawing ☐ Finish ☐ Misread ☐ Turning Sequence ☐	OTHER : _____	

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Item ID: D205-541-045 Accept ***N900040100*** Setup Start ***NS1***
 Revision ID: Stop ***NS2***
 Item Name: Heli-Utility-Basket™ - LH Low Profile
 Start Date: 7/8/2016 Start Qty: 1.00 ***1*** Cust Item ID:
 Required Date: 7/25/2016 Req'd Qty: 1.00 ***1*** Customer:
 Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____ Run Start ***NR1***
 QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
150	Packaging	0.00							
150									
Packaging	Memo	0.00							
Packaging	Identify and pack for shipping as per PPP D205-541-045 Location: _____ PPP Rev: _____								
160	QC21- Final Inspection - Work Order Release	0.00							
160									
QC	Memo	0.02							
Quality Control									

SMB
16/7/29

HJ / ~~REB~~ 16/07/29.
82m 16/07/29

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____		DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐		AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐					
Date :		Step #:		QTY Effective :			MRB (QSI042) Approval Completed By Lead hand / Supervisor Approval Verification QC / QA Coordinator Approval		
Description Work Order Deviation				Disposition					

Root Cause		FAULT CATEGORY					
Environment ☐	No Re-verification ☐	Pressure/Forced ☐	Temperature/Cure ☐	Power Loss/Surge ☐	Positioned Wrong ☐		
Design ☐	Operator ☐	Bending ☐	Set-up ☐	Folio/Program ☐	Outside Dimensions ☐		
Doc/Data ☐	Offset/Setup ☐	Centre Not Concentric ☐	BOM/Route ☐	Grain ☐	Over/Under tolerance ☐		
Equip/Tooling ☐	Supplier ☐	Cracks ☐	Broken/Damage/Defect ☐	Weld ☐	Part Incorrect ☐		
Handling/Pre ☐	Training ☐	Crimp/Kink/Ripple/Wave ☐	Inspection Incomplete/Unqualified ☐	Wrong Stock Pulled ☐	Part Lost/Missing ☐		
Material ☐	Use for Testing ☐	Cuffs ☐	Contamination ☐	Out of Sequence ☐	Part Moved ☐		
Internal Transport ☐	Poor Information ☐	Crushing ☐	Countersink ☐	Off-set ☐	Drawing ☐		
Tribal Knowledge ☐	Rushing ☐	Heat Treat ☐	Cut Too Short ☐	Mislabeled ☐	Finish ☐		
LOA ☐	Product Improvement ☐	Wave/Twist in Tube ☐	Instructions Incomplete/Unclear ☐	Fit/Function ☐	Misread ☐		
Substation ☐	Process Improvement ☐	Marks/Chatter ☐	Drill Holes ☐	Misaligned/off center ☐	Turning Sequence ☐		
Past Expiry Date ☐	Manufacturing Process ☐	OTHER : _____					
Misidentified ☐	Past Due ☐						

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Work Order ID: 148457

148457

Parent Item: D205-541-045

D205-541-045

Parent Item Name: Heli-Utility-Basket™ - LH Low Profile

Start Date: 7/8/2016

Required Date: 7/25/2016

Start Qty: 1.00

Required Qty: 1.00

Comments:

IPP Rev:A new issue 08-02-15 DD verified by:

IPP Rev:B Ecn 1157 08-03-19 DD verified by:

15.02.02 AS PER DIS9667 DD VERF:JLM

IPP REV:C

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
---------------------------------	------------------------	---------------	-------------	---------------------	------------------	-----------------	--------------------	----------------	-------------	--------------	---------------	----------------	--------

AN3-16A

Purchased

No

110

Each

92.0000

2

AN3-16A

Bolt

**

② X 134943 PC

Location

Loc Qty

Loc Code

GA

45

117441

45

ST348

47

M133790

5

M134943

42

AN4-20A

Purchased

No

110

Each

170.0000

3

AN4-20A

Bolt

**

PC

Location

Loc Qty

Loc Code

GA

6

m116419

6

over003

50

m135056

50

ST343

114

m134943

114

JUL 22 2016

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Work Order ID: 148457

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Parent Item: D205-541-045

D205-541-045

Parent Item Name: Heli-Utility-Basket™ - LH Low Profile

Start Date: 7/8/2016

Required Date: 7/25/2016

Start Qty: 1.00

Required Qty: 1.00

AN4-22A Purchased No 110 Each 124.0000 1 1

AN4-22A

Bolt

PC

Location

Loc Qty

Loc Code

GA 50
116419 50
ST342 74
123348 74

AN4-24A Purchased No 110 Each 68.0000 1 1

AN4-24A

Bolt

PC

Location

Loc Qty

Loc Code

ST342 13
M126175 13
ST343 55
128403 55

AN5-17A Purchased No 110 Each 123.0000 4 4

AN5-17A

Bolt

PC

Location

Loc Qty

Loc Code

GA 29
117872 29
over003 75
m134762 75
ST337 19
m134606 19

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Work Order ID: 148457

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Parent Item: D205-541-045

D205-541-045

Parent Item Name: Heli-Utility-Basket™ - LH Low Profile

Start Date: 7/8/2016

Required Date: 7/25/2016

Start Qty: 1.00

Required Qty: 1.00

AN5-7A Purchased No 110 Each 4,077.000 1 1

AN5-7A

Bolt

**

PC

Location

Loc Qty

Loc Code

over009

4077

M119017

2400

M123355

1510

m126010

167

AN970-4 Purchased No 110 Each 78.0000 4 4

AN970-4

Washer

**

PC

Location

Loc Qty

Loc Code

ST260a

50

m133769

50

ST321

28

m133992

28

D2332-041 Manufactured No 110 Each 9.0000 1 1

D2332-041

Lid Prop Assembly 6.69"

**

PC

Location

Loc Qty

Loc Code

FG

2

132567

1

89226

1

ST255

7

145384

7

D2530 Manufactured No 110 Each 4.0000 1 1

D2530

Handle Weldment

**

PC

Location

Loc Qty

Loc Code

ST379

4

145413

4

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Work Order ID: 148457

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Parent Item: D205-541-045

D205-541-045

Parent Item Name: Heli-Utility-Basket™ - LH Low Profile

Start Date: 7/8/2016

Required Date: 7/25/2016

Start Qty: 1.00

Required Qty: 1.00

D2535 Manufactured No 110 Each 65.0000 2 2

D2535

Spring

PK

Location Loc Qty Loc Code

ST008 40

143808 15

144488 25

ST012a 25

146275 25

2

D2537 Manufactured No 110 Each 23.0000 2 2

D2537

Bushing

PK

Location Loc Qty Loc Code

ST008 23

141583 23

2

D3712-041 Manufactured No 110 Each 0.0000 1 1

D3712-041

Basket Base Assembly

B148454 (w) 16/07/29

D3713-041 Manufactured No 110 Each 0.0000 1 1

D3713-041

Lid Assembly

B148461 (w) 16/07/29

D3723-1 Manufactured No 110 Each 35.0000 6 6

D3723-1

Bushing

PK

Location Loc Qty Loc Code

ST052 35

85428 11

86294 24

6

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Work Order ID: 148457

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Parent Item: D205-541-045

D205-541-045

Parent Item Name: Heli-Utility-Basket™ - LH Low Profile

Start Date: 7/8/2016

Required Date: 7/25/2016

Start Qty: 1.00

Required Qty: 1.00

MS21042L3

Purchased

No

110

Each

1,713.000

2

2

MS21042L3

Nut

PC

Location

Loc Qty

Loc Code

CCK007

600

m135056

600

FP001

32

m133790

32

GA

158

m133790

3

m134360

155

ST303

923

m134039

12

m134634

2

m134754

109

m134943

800

2

MS21042L4

Purchased

No

110

Each

1,981.000

5

5

MS21042L4

Locknut

PE

Location

Loc Qty

Loc Code

FP001

51

m133363

51

GA

156

m133769

156

OVER007

500

m134955

500

ST303

1180

m127376

12

m134861

668

m135058

500

ST305

94

m130922

94

5

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Work Order ID: 148457

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Parent Item: D205-541-045

D205-541-045

Parent Item Name: Heli-Utility-Basket™ - LH Low Profile

Start Date: 7/8/2016

Required Date: 7/25/2016

Start Qty: 1.00

Required Qty: 1.00

MS21042L5

Purchased

No

110

Each

501.0000

4

4

MS21042L5

Nut

PL

Location

Loc Qty

Loc Code

GA	83	
m127813	83	
OVER007	250	
m134509	100	
m134955	150	<i>4</i>
ST303	168	
m134055	6	
m134762	62	
m135058	100	

NAS1149D0416J

Purchased

No

110

Each

3,973.000

2

2

NAS1149D0416J

WASHER

PL

Location

Loc Qty

Loc Code

GA	119	
m131511	119	
ST260a	1984	
m131511	1984	
ST264	1870	
m131511	1870	<i>2</i>

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Required Date: 7/25/2016

Start Qty: 1.00

Required Qty: 1.00

NAS1149D0463J

Purchased

No

110

Each

3,463.000

6

6

NAS1149D0463.J

PC

WASHER

Location

Loc Qty

Loc Code

GA

86

M132035

21

M134508

65

ST260a

3000

M134852

1000

M134943

1000

M135056

1000

ST263

377

M127693

24

M134754

353

6

NAS1149D0563J

Purchased

No

110

Each

1,425.000

4

4

NAS1149D0563.J

PC

Washer

Location

Loc Qty

Loc Code

GA

211

m125807

2

m133769

209

ST263

1115

m134497

315

m135058

800

ST269

99

m128257

99

4

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Start Date: 7/8/2016

Required Date: 7/25/2016

Start Qty: 1.00

Required Qty: 1.00

AN4-12A Purchased No 130 Each 135.0000 3 3

AN4-12A
Bolt

PC

DAS
27
9-89

Location	Loc Qty	Loc Code
FG	10	
120423	10	
ST344	125	
m134606	125	

AN4-13A Purchased No 130 Each 555.0000 9 9

AN4-13A
Bolt

PC

DAS
27
9-89

Location	Loc Qty	Loc Code
FG	20	
122808	20	
GA	59	
m134167	35	
m134634	24	
over003	100	
m134943	100	
ST343	376	
m134852	376	

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Start Date: 7/8/2016

Required Date: 7/25/2016

Start Qty: 1.00

Required Qty: 1.00

AN4-14A Purchased No 130 Each 371.0000 2 2

AN4-14A

Bolt

**

PC DAS 28 9-89

DAS 27 9-89

Location	Loc Qty	Loc Code
FG	5	
122141	5	
over003	250	
M134754	100	
<u>M134943</u>	150	2
ST344	116	
M134573	16	
M135056	100	

AN4-7A Purchased No 130 Each 89.0000 2 2

AN4-7A

Bolt

**

PC DAS 28 9-89

DAS 27 9-89

Location	Loc Qty	Loc Code
ST345	89	
m134249	3	
m134754	86	

AN5-13A Purchased No 130 Each 38.0000 1 1

AN5-13A

BOLT

**

PC DAS 28 9-89

DAS 27 9-89

Location	Loc Qty	Loc Code
CA	2	
m129682	2	
over003	20	
m134754	20	
ST338	16	
<u>m134497</u>	16	1

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Parent Item Name: Heli-Utility-Basket™ - LH Low Profile

Start Date: 7/8/2016

Required Date: 7/25/2016

Start Qty: 1.00

Required Qty: 1.00

D2199-1

Manufactured No

130

Each

0.0000

1 1

**

D2199-1

Struts, 19"

D2199-23

Manufactured No

130

Each

1.0000

1 1

**

D2199-23

Strut

Location

Loc Qty

Loc Code

ST352

1

141474

1

D2199-25

Manufactured No

130

Each

1.0000

1 1

**

D2199-25

Strut

Location

Loc Qty

Loc Code

Mezz

1

103102

1

D2498

Manufactured No

130

Each

8.0000

1 1

**

D2498

Mounting Lug

Location

Loc Qty

Loc Code

ST527

8

132237

8

D2499

Manufactured No

130

Each

9.0000

1 1

**

D2499

Mounting Bracket

Location

Loc Qty

Loc Code

ST527

9

132820

8

137488

1

B149747

X B148462

B148463

PC

PC

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Parent Item Name: Heli-Utility-Basket™ - LH Low Profile

Start Date: 7/8/2016

Required Date: 7/25/2016

Start Qty: 1.00

Required Qty: 1.00

D2515 Manufactured No

130 Each

5.0000

2 2

D2515

Bushing DAS
27
9-89

**

PC DAS
28
9-89

Location

Loc Qty

Loc Code

ST007

5

137401

5

2

D3052-1

Manufactured No

130 Each

4.0000

1 1

D3052-1

Mounting Lug

**

PC DAS
28
9-89

Location

Loc Qty

Loc Code

ST536

4

40200

4

1

MS21042L4

Purchased No

130 Each

1,981.000

16 16

MS21042L4

Locknut

**

PC

DAS
28
9-89

Location

Loc Qty

Loc Code

FP001

51

m133363

51

GA

156

m133769

156

OVER007

500

m134955

500

16

ST303

1180

m127376

12

m134861

668

m135058

500

ST305

94

m130922

94

JUL 22 2016

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Shop Packet Print

Page 11

Picklist Print

June 30, 2016 2:11:54 PM

Work Order ID: 148457

148457

Parent Item: D205-541-045

D205-541-045

Parent Item Name: Heli-Utility-Basket™ - LH Low Profile

Start Date: 7/8/2016

Required Date: 7/25/2016

Start Qty: 1.00

Required Qty: 1.00

NAS1149D0432J Purchased No 130 Each 833.0000 4 4

NAS1149D0432.J

WASHER

**

PC DAS 28 9-89

DAS
27
9-89

Location

Loc Qty

Loc Code

GA	26	
m131026	26	
ST264	807	
m134676	807	

NAS1149D0463J Purchased No 130 Each 3,463.000 31 31

NAS1149D0463.J

WASHER

**

PC DAS 28 9-89

SMB

Location

Loc Qty

Loc Code

GA	86	
M132035	21	
M134508	65	
ST260a	3000	
M134852	1000	
M134943	1000	
M135056	1000	
ST263	377	
M127693	24	
M134754	353	

NAS1149D0532J Purchased No 130 Each 184.0000 2 2

NAS1149D0532.J

WASHER

**

PC DAS 28 9-89

DAS
27
9-89

5

Location

Loc Qty

Loc Code

ST264	184	
m131467	184	

2

JUL 22 2016

Picklist Print

June 30, 2016 2:11:54 PM

Work Order ID: 148457

148457

Parent Item: D205-541-045

D205-541-045

Parent Item Name: Heli-Utility-Basket™ - LH Low Profile

Start Date: 7/8/2016

Required Date: 7/25/2016

Start Qty: 1.00

Required Qty: 1.00

NAS1149D0563J

Purchased

No

130

Each

1,425.000

5

5

NAS1149D0563.J

Washer

PC
DAS
28
9-89

DAS
28
9-89

Location

Loc Qty

Loc Code

GA	211	
m125807	2	
m133769	209	
ST263	1115	
m134497	315	
m135058	800	
ST269	99	
m128257	99	

JUL 22 2016

148 457

DART SERVICE INSTRUCTION

TO AMEND INSTALLATION INSTRUCTIONS D205-541 REV. J AND
INSTRUCTIONS FOR CONTINUED AIRWORTHINESS ICA-D205-541 REV. 4
REF TCCA STC: SH96-120
REF FAA STC: SR00696NY
REF EASA STC: EASA.IM.R.S.01242

PURPOSE:

FOR CUSTOMERS/OPERATORS CONCERNED WITH GAPS AT STA's 84.29, 129.00 AND 155.06 WHILE INSTALLING D205-541-043/-044/-045/-046 BASKETS, IT IS ACCEPTABLE TO FILL THE GAPS WITH WASHERS TO REDUCE UNNECESSARY STRESS ON THE MOUNTING LUGS.

CHANGE:

INSTALL THE D205-541-043/-044/-045/-046 BASKET KITS PER INSTALLATION INSTRUCTIONS D205-541 WITH ADDITIONAL WASHERS AS SHOWN IN FIGURE 1 OF THIS SERVICE INSTRUCTION.

PARTS LIST:

THE PARTS LISTS FOR D205-541-043/-044 AT CHG 003 OR LATER AND D205-541-045/-046 AT CHG 002 OR LATER ARE AMENDED AS FOLLOWS:

25.8 D205-541 INSTALLATION PARTS LIST (ICA-D205-541)

5.2 D205-541-043 INSTALLATION PARTS LIST (D205-541)

QTY -043	QTY -044	QTY -045	QTY -046	PART NUMBER	DESCRIPTION
X				D205-541-043	HELI-UTILITY-BASKET-LH
	X			D205-541-044	HELI-UTILITY-BASKET-RH
		X		D205-541-045	HELI-UTILITY-BASKET-LH
			X	D205-541-046	HELI-UTILITY-BASKET-RH

ADD:

4	4	4	4	NAS1149D0463J	WASHER
4	4	4	4	NAS1149D0432J	WASHER
2	2	2	2	NAS1149D0532J	WASHER
2	2	2	2	NAS1149D0563J	WASHER

WEIGHT AND BALANCE:

THERE IS NEGLIGIBLE WEIGHT CHANGE ASSOCIATED WITH THIS MODIFICATION.

MAINTENANCE:

PER ICA-D205-541.

CANADA DEPARTMENT OF TRANSPORT AIRCRAFT CERTIFICATION BRANCH DAO # 01-O-01
APPROVED 
BY: <u>D. SHEPHERD (DE # 02)</u>
DATE: <u>14.11.27</u>
CERT. NO.: <u>SH96-120</u>
ISSUE NO.: <u>3</u>

A	NEW ISSUE	DW	14.11.27
REV.	DESCRIPTION	BY	DATE
DESIGN	DW	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	DW		
CHECKED	AP	DRAWING NO. REV. A	
MFG. APPR.	N/A	DSI 9667 SHEET 1 OF 2	
APPROVED		TITLE SCALE	
DE APPR.		WASHER ADDITION NTS	
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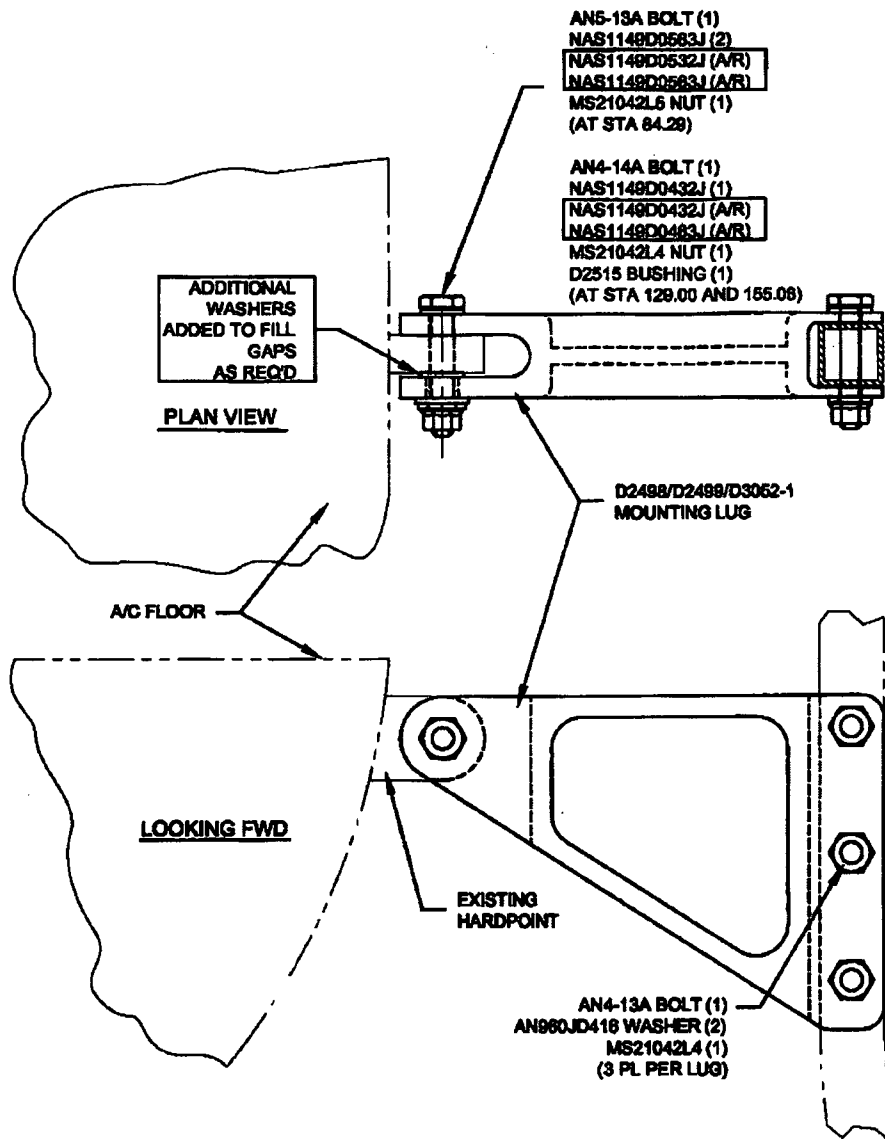


FIGURE 1

REF FIGURE 6 OF D205-541 REV. J

REF FIGURE 25-8 OF ICA-D205-541 REV. 4

CANADA
DEPARTMENT OF TRANSPORT
AIRCRAFT CERTIFICATION
BRANCH
DAO # 01-O-01

APPROVED

BY: *[Signature]*
D. SHEPHERD (DE # 02)

DATE: 14.11.27
CERT. NO.: SH88-120
ISSUE NO.: 3

DESIGN	DW	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	DW		
CHECKED	AP	DRAWING NO.	REV. A
MFG. APPR.	N/A	DSI 9667	SHEET 2 OF 2
APPROVED	<i>[Signature]</i>	TITLE	SCALE
DE APPR.		WASHER ADDITION	NTS
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Qty -043	Qty -044	Qty -045	Qty -046	Qty -141	Qty -142	Part Number	Description
1*	1*	1*	1*			AN4-22A	BOLT
1*	1*	1*	1*			AN4-24A	BOLT
1	1	1	1			AN5-7A	BOLT
1	1	1	1			AN5-13A	BOLT
4*	4*	4*	4*			AN5-17A	BOLT
				5	5	AN960-10	WASHER (OR NAS1149F0363P) (OPTIONAL)
				20	20	AN960JD10L	WASHER (OR NAS1149D0332J)
2*	2*	6*	6*			AN960JD416	WASHER (OR NAS1149D0463J)
				2	2	AN960-416	WASHER (OR NAS1149F0463P) (OPTIONAL)
27	27	27	27	36	36	AN960JD416	WASHER (OR NAS1149D0463J)
2*	2*	2*	2*	4	4	AN960JD416L	WASHER (OR NAS1149D0416J)
4*	4*	4*	4*			AN960JD516	WASHER (OR NAS1149D0563J)
3	3	3	3			AN960JD516	WASHER (OR NAS1149D0563J)
2	2					AN960JD8	WASHER (OR NAS1149DN832J)
4*	4*	4*	4*			AN970-4	WASHER
2*	2*					MS20600AD4W3	RIVET
2*	2*	2*	2*	8	8	MS21042L3	NUT (OR MS21042-3)
				5	5	MS21042L3	NUT (OR MS21042-3) (OPTIONAL)
4*	4*	5*	5*			MS21042L4	NUT (OR MS21042-4)
16	16	16	16	20	20	MS21042L4	NUT (OR MS21042-4)
				2	2	MS21043L4	NUT (OR MS21043-4)
4*	4*	4*	4*			MS21042L5	NUT (OR MS21042-5)
2	2	2	2			MS21042L5	NUT (OR MS21042-5)

* = ASSEMBLED AT DART

6.0 PARTS LIST HELI-ACCESS-STEP™

Qty -047	Qty -048	Part Number	Description
X		D205-541-047	HELI-ACCESS-STEP, LH
	X	D205-541-048	HELI-ACCESS-STEP, RH
1		D3724-041	STEP ASSY, LH
	1	D3724-042	STEP ASSY, RH
2	2	D3731-1	PLATE
2	2	D3751-1	SHIM
6	6	AN4-13A	BOLT
6	6	AN4-14A	BOLT
24	24	AN960JD416	WASHER
12	12	MS21042L4	NUT (OR MS21042-4)

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Revision: J

Date: 10.03.08

REFERENCE 0000

DART SERVICE INSTRUCTION

TO AMEND INSTALLATION INSTRUCTIONS D205-541 REV. J AND
INSTRUCTIONS FOR CONTINUED AIRWORTHINESS ICA-D205-541 REV. 4
REF TCCA STC: SH96-120
REF FAA STC: SR00696NY
REF EASA STC: EASA.IM.R.S.01242

PURPOSE:

FOR CUSTOMERS/OPERATORS CONCERNED WITH GAPS AT STA's 84.29, 129.00 AND 155.06 WHILE INSTALLING D205-541-043/-044/-045/-046 BASKETS, IT IS ACCEPTABLE TO FILL THE GAPS WITH WASHERS TO REDUCE UNNECESSARY STRESS ON THE MOUNTING LUGS.

CHANGE:

INSTALL THE D205-541-043/-044/-045/-046 BASKET KITS PER INSTALLATION INSTRUCTIONS D205-541 WITH ADDITIONAL WASHERS AS SHOWN IN FIGURE 1 OF THIS SERVICE INSTRUCTION.

PARTS LIST:

THE PARTS LISTS FOR D205-541-043/-044 AT CHG 003 OR LATER AND D205-541-045/-046 AT CHG 002 OR LATER ARE AMENDED AS FOLLOWS:

25.8 D205-541 INSTALLATION PARTS LIST (ICA-D205-541)

5.2 D205-541-043 INSTALLATION PARTS LIST (D205-541)

QTY -043	QTY -044	QTY -045	QTY -046	PART NUMBER	DESCRIPTION
X				D205-541-043	HELI-UTILITY-BASKET-LH
	X			D205-541-044	HELI-UTILITY-BASKET-RH
		X		D205-541-045	HELI-UTILITY-BASKET-LH
			X	D205-541-046	HELI-UTILITY-BASKET-RH

ADD:

4	4	4	4	NAS1149D0463J	WASHER
4	4	4	4	NAS1149D0432J	WASHER
2	2	2	2	NAS1149D0532J	WASHER
2	2	2	2	NAS1149D0563J	WASHER

WEIGHT AND BALANCE:

THERE IS NEGLIGIBLE WEIGHT CHANGE ASSOCIATED WITH THIS MODIFICATION.

MAINTENANCE:

PER ICA-D205-541.

CANADA
DEPARTMENT OF TRANSPORT
AIRCRAFT CERTIFICATION
BRANCH
DAO # 01-O-01

APPROVED
[Signature]

BY: D. SHEPHERD (DE # 02)

DATE: 14.11.27

CERT. NO.: SH96-120

ISSUE NO.: 3

A	NEW ISSUE	DW	14.11.27
REV.	DESCRIPTION	BY	DATE
DESIGN	DW	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	DW		
CHECKED	AP	DRAWING NO. REV. A	
MFG. APPR.	N/A	DSI 9667 SHEET 1 OF 2	
APPROVED	<i>[Signature]</i>	TITLE SCALE	
DE APPR.	<i>[Signature]</i>	WASHER ADDITION NTS	
DATE 14.11.27		COPYRIGHT © 2014 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.	

4.0 WEIGHT AND BALANCE

Installation	Weight	LATERAL		LONGITUDINAL	
		Arm	Moment	Arm	Moment
D205-541-043 <i>Heli-Utility-Basket™</i>	118 lb 53.6 kg	- 63.13 in - 1.60 m	- 7449 in-lb - 85.8 m-kg	132.25 in 3.36 m	15606 in-lb 180.1 m-kg
D205-541-044 <i>Heli-Utility-Basket™</i>	118 lb 53.6 kg	+ 63.13 in + 1.60 m	+ 7449 in-lb + 85.8 m-kg	132.25 in 3.36 m	15606 in-lb 180.1 m-kg
D205-541-045 <i>Heli-Utility-Basket™</i>	104 lb 47.3 kg	- 63.13 in - 1.60 m	- 6566 in-lb - 75.7 m-kg	132.25 in 3.36 m	13754 in-lb 158.9 m-kg
D205-541-046 <i>Heli-Utility-Basket™</i>	104 lb 47.3 kg	+ 63.13 in + 1.60 m	+ 6566 in-lb + 75.7 m-kg	132.25 in 3.36 m	13754 in-lb 158.9 m-kg
D205-541-047 <i>Heli-Access-Step™</i>	14 lb 6.4 kg	- 76.11 in - 1.93 m	- 1066 in-lb - 12.4 m-kg	126.56 in 3.21 m	+ 1772 in-lb + 20.5 m-kg
D205-541-048 <i>Heli-Access-Step™</i>	14 lb 6.4 kg	+ 76.11 in + 1.93 m	+ 1066 in-lb + 12.4 m-kg	126.56 in 3.21 m	+ 1772 in-lb + 20.5 m-kg
D205-541-141 <i>Heli-Utility-Basket™</i>	69 lb 31.4 kg	- 59.9 in - 1.5 m	- 4133 in-lb - 47.1 m-kg	161.6 in 4.1 m	+ 11150 in-lb + 128.7 m-kg
D205-541-142 <i>Heli-Utility-Basket™</i>	69 lb 31.4 kg	+ 59.9 in + 1.5 m	+ 4133 in-lb + 47.1 m-kg	161.6 in 4.1 m	+ 11150 in-lb + 128.7 m-kg

5.0 PARTS LIST HELI-UTILITY-BASKET™

Qty -043	Qty -044	Qty -045	Qty -046	Qty -141	Qty -142	Part Number	Description
X						D205-541-043	HELI-UTILITY-BASKET, LH
	X					D205-541-044	HELI-UTILITY-BASKET, RH
		X				D205-541-045	HELI-UTILITY-BASKET, LH
			X			D205-541-046	HELI-UTILITY-BASKET, RH
				X		D205-541-141	HELI-UTILITY-BASKET, LH
					X	D205-541-142	HELI-UTILITY-BASKET, RH
				1	1	DSI 9302-011	STRUT MODIFICATION KIT (FOR D205-633 STEP INSTALLATION)
2*	2*					D2022-101	SPACER
				2	2	D2022-101	SPACER (FOR D205-633 STEP INSTALLATION)
1	1	1	1			D2199-1	STRUT
1	1	1	1			D2199-23	STRUT
1	1	1	1			D2199-25	STRUT
1*	1*	1*	1*			D2258-300	LABEL
1*	1*	1*	1*			D2332-041	PROP ASSEMBLY
				1	1	D2332-041	PROP ASSEMBLY (OPTIONAL)
				1	1	D2464-0410	NEOPRENE SEAL
1	1	1	1			D2498	MOUNTING LUG
1	1	1	1			D2499	MOUNTING LUG
1*	1*					D2512	BASKET LID ASSEMBLY

Qty -043	Qty -044	Qty -045	Qty -046	Qty -141	Qty -142	Part Number	Description
2	2	2	2			D2515	BUSHING
1*	1*	1*	1*			D2530	HANDLE ASSEMBLY
2*	2*	2*	2*			D2535	SPRING
2*	2*	2*	2*			D2537	BUSHING
2*	2*					D2931	BUMPER
1	1	1	1			D3052-1	MOUNTING LUG
1*						D3053-041	BASKET BASE ASSEMBLY, LH
	1*					D3053-042	BASKET BASE ASSEMBLY, RH
		1*				D3712-041	BASKET BASE
			1*			D3712-042	BASKET BASE
		1*				D3713-041	LID ASSEMBLY
			1*			D3713-042	LID ASSEMBLY
		6*	6*			D3723-1	BUSHING
				2	2	D3953-9	GAS SPRING SPACER (OPTIONAL)
				1		D4041-011	SHORT BASKET ASS'Y, LH
					1	D4041-012	SHORT BASKET ASS'Y, RH
				1		D4048-041	MOUNTING LUG ASS'Y
					1	D4048-042	MOUNTING LUG ASS'Y
				1		D4048-5	MOUNTING LUG
					1	D4048-6	MOUNTING LUG
				1		D4048-7	MOUNTING LUG
					1	D4048-8	MOUNTING LUG
				6	6	D4048-9	BUSHING
				1		D4049-041	MOUNTING LUG ASS'Y
					1	D4049-042	MOUNTING LUG ASS'Y
				1		D4049-5	MOUNTING LUG
					1	D4049-8	MOUNTING LUG
				1	1	D4050-1	STRUT
				1	1	D4050-3	STRUT
				1		D4050-5	STRUT
					1	D4050-8	STRUT
				1		D4051-041	GUARD (OPTIONAL)
					1	D4051-042	GUARD (OPTIONAL)
				2	2	D4052-1	EYE BOLT
				10	10	AN3-5A	BOLT
				1	1	AN3-7A	BOLT (OPTIONAL)
				4	4	AN3-11A	BOLT (OPTIONAL)
2*	2*	2*	2*			AN3-16A	BOLT
				5	5	AN4-6A	BOLT
2*	2*					AN4-7A	BOLT
2	2	2	2	1	1	AN4-7A	BOLT
3	3	3	3	2	2	AN4-12A	BOLT
9	9	9	9			AN4-13A	BOLT
2	2	2	2	11	11	AN4-14A	BOLT
				1	1	AN4-16A	BOLT
		3*	3*			AN4-20A	BOLT

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Revision: J

Date: 10.03.08

Work Order ID 148457

June 30, 2016 2:11:49 PM

148457

Page 1

Item ID: D205-541-045

Accept

N900040100

Setup Start ***NS1***

Revision ID:

Item Name: Heli-Utility-Basket™ - LH Low Profile

Stop ***NS2***

Start Date: 7/8/2016 Start Qty: 1.00 ***1***

Cust Item ID:

Required Date: 7/25/2016 Req'd Qty: 1.00 ***1***

Customer:

Reference:

Approvals: Process Plan: SW Date: 6/30/16 Tooling: _____ Date: _____
QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Run Start ***NR1***
Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
Draw Nbr	Revision Nbr								
DSI9667	A								
IIN D205-541	J								

PC

JUL 22 2016

DAS
21
9-89

JUL 22 2016

100 Document Control 0.00
100 DOCUMENT CONTROL
DC Memo 0.00
Doc.Control -USB or Paperwork Photocopy bluefile & type labels per PPPD205-541-045 CHG002

110 Small Fab 0.00
110 Small Fab Memo 0.23
Small Fab 1-install bumper as per dwg D3712 2-Assemble as per IIN 205-541-045